

1.需打钢印
2.需喷码
3.表面处理见第五页

钢印要求（上海电气）：

SWP CN 07214 18 01 001
A9B10193396
SWP: 西门子公司
CN: 中国 (零件运往何处)
07214: 飞跃代码
18: 生产年份 (根据实际生产年份)
01: 生产月份 (根据实际生产月份)
001: 序号从001-999
A9B10193396: 零部件物料号

字体高度10mm

Note1	All dimensions are in mm.
Note2	In case of conflict between requirements of 2d-drawing and any received reference 3d file or DXF file, then the requirements on the 2d-drawing shall prevail.
Note3	General tolerances: For unspecified measurements the tolerance classes listed below apply: The tolerances for linear dimensions: Tolerance class A acc. to ISO 13920:1996; The tolerances for angular dimensions: Tolerance class A acc. to ISO 13920:1996; Tolerances for straightness, flatness, and parallelism: Tolerance class E acc. to ISO 13920:1996.
Note4	Part with position no 2 and part with position no 3 can be processed as one part.

Pos	Qty	Dimension	Alt. Dim. 1	Alt. Dim. 2	Mat. req.	Purch. spec.	Mass
1	1	IPB 900-DIN 1025-2			S355J2 UT 1,2/2,4	Gr. 2.1 ZPS 1009554	1716,8kg
2	1	PI 150 mm.			S355NL UT S3/P	Gr. 2.2 ZPS 1009554	233,9kg
3	2	Pl. 15 mm.			S355J2	Gr. 2.1 ZPS 1009554	9,7kg

Weight app.: 1932,6 kg	Proprietary class: Restricted	EC 3
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Part:	Main beam, RESS	Draw. format:	ISO	Draw. scale	Sheet no.:
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Siemens Wind Power A/S



上海电气风电集团有限公司
Shanghai Electric Wind Power Group Co., Ltd.

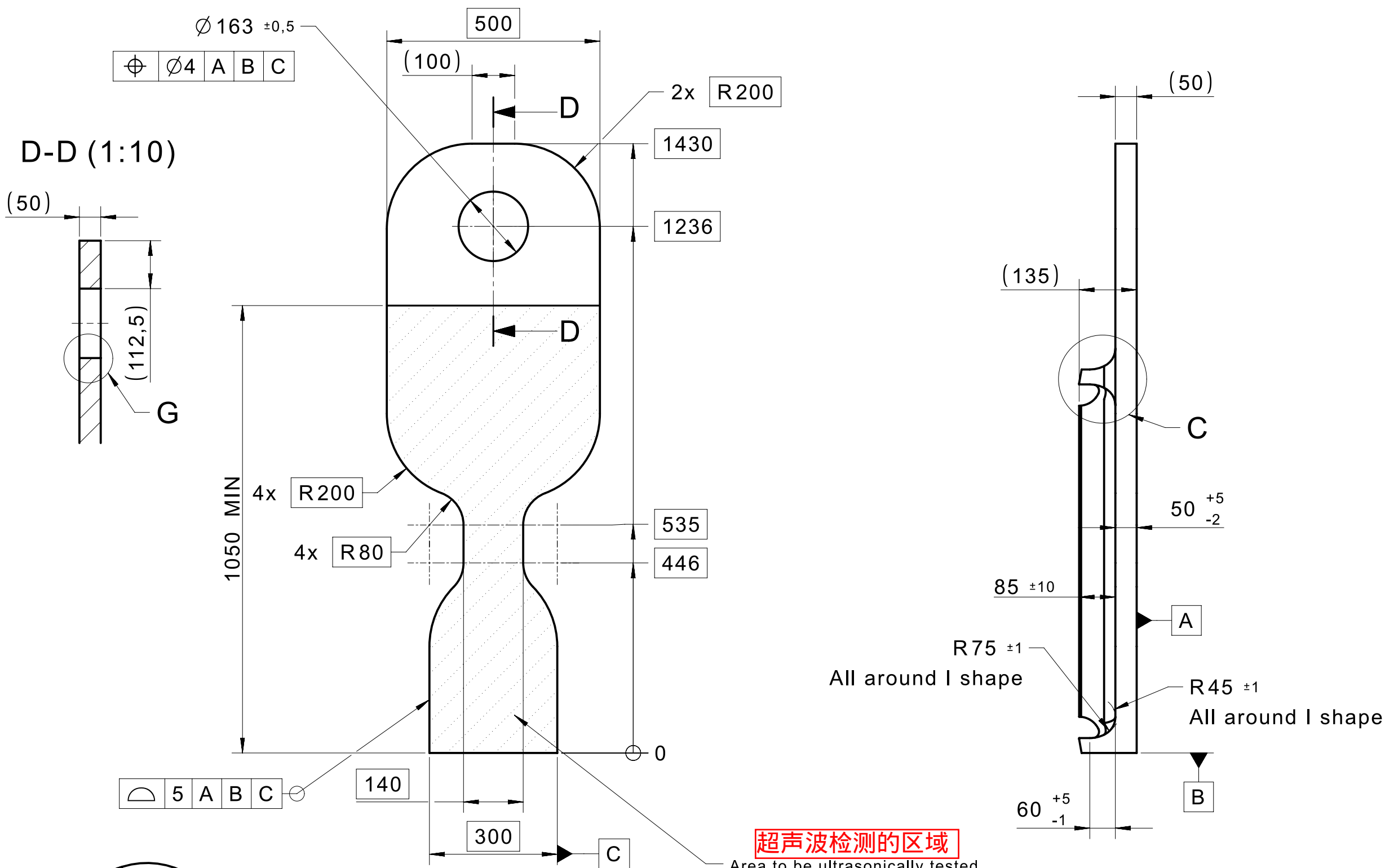
ECN No.:	Revision:
001245	001

D1350030

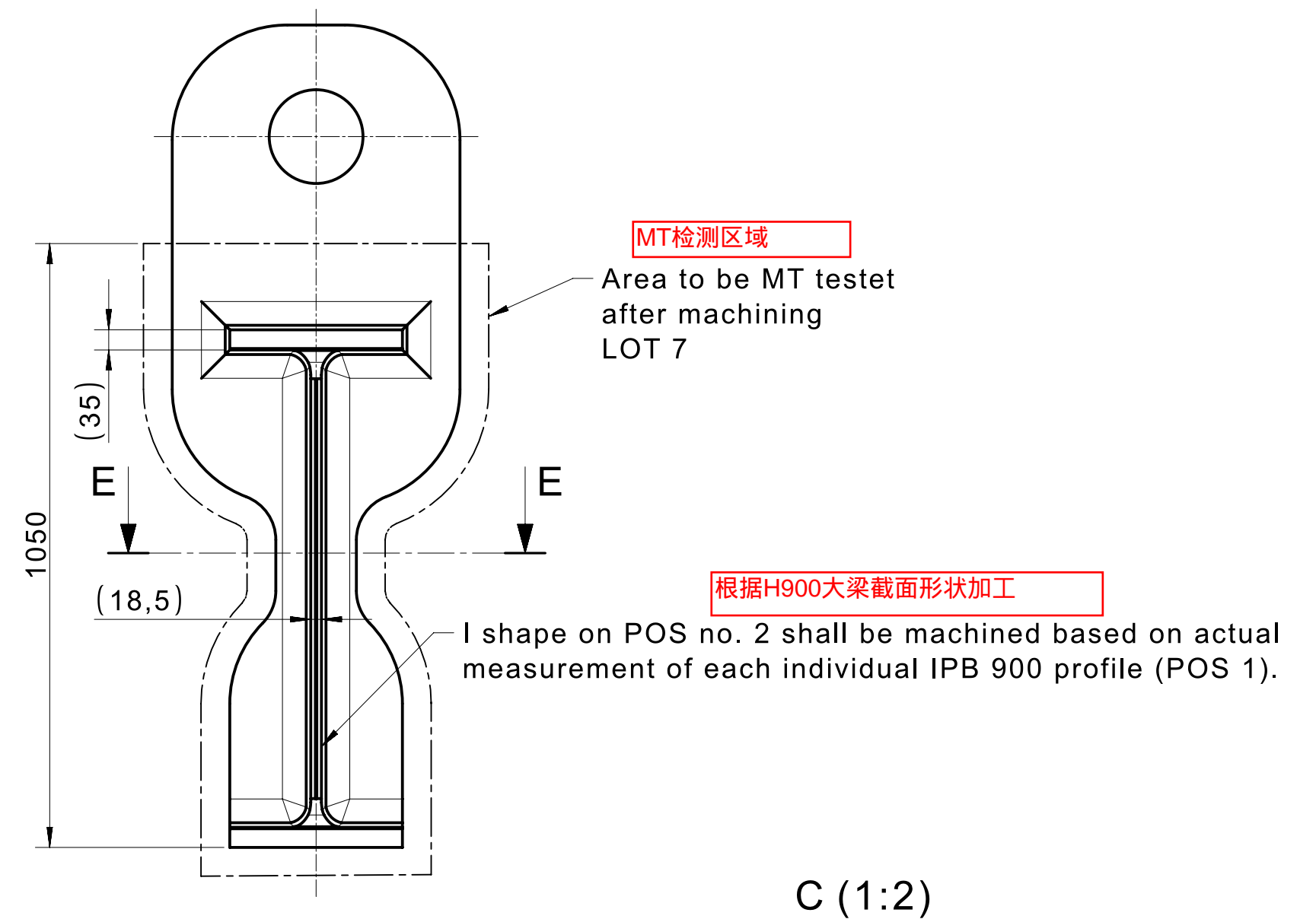
A9B10193396

Additional technical requirements
Additional requirements regarding base-material, welding, non destructive testing, surface treatment etc. see submitted technical specifications given by the purchase order.

Machined part POS 2 (1 : 10)

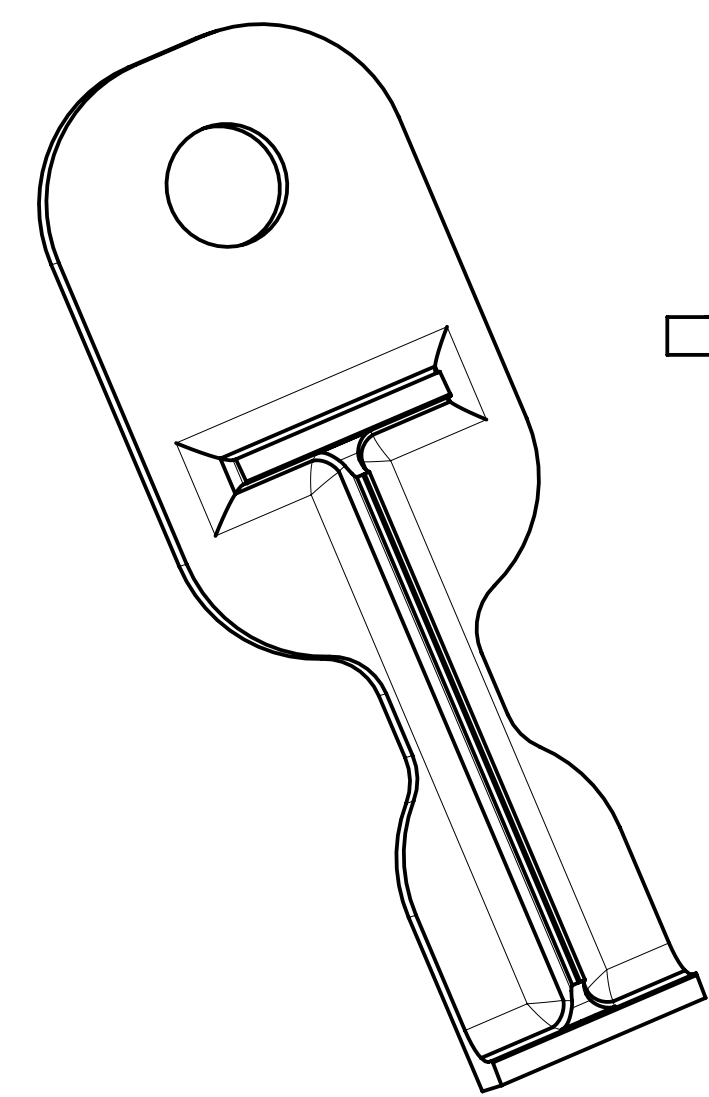


超声波检测的区域
Area to be ultrasonically tested.
(Acceptance level - See specified requirements for constituent product)

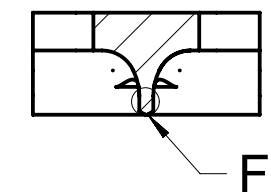


MT检测区域
Area to be MT testet
after machining
LOT 7

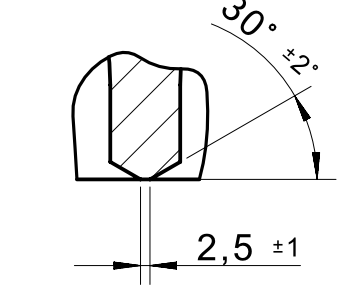
根据H900大梁截面形状加工
I shape on POS no. 2 shall be machined based on actual
measurement of each individual IPB 900 profile (POS 1).



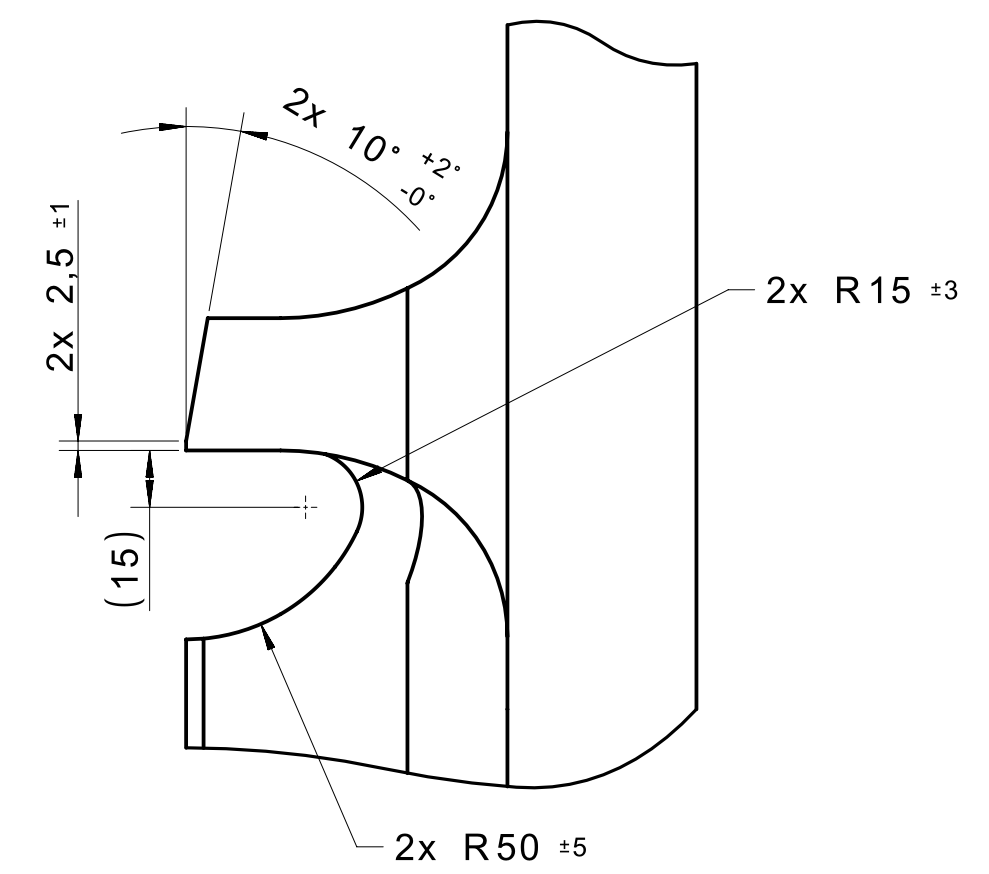
E-E (1:10)



F (1:2)



C (1:2)



Additional technical requirements
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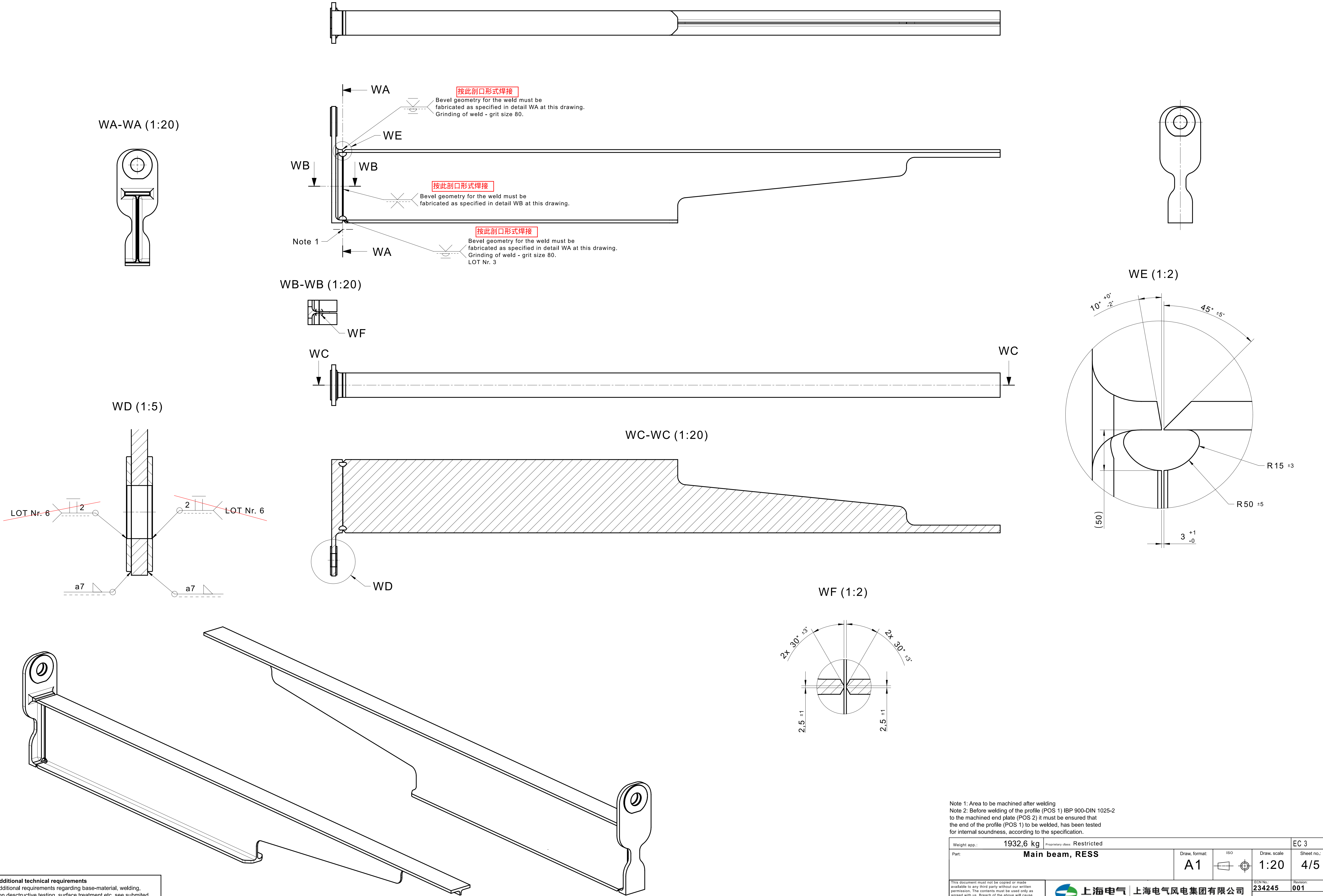
Overflader uden ruhedsangivelse: Bebejdet til Rz 50
Surfaces without spec. roughness: Machined to Rz 50

表面粗糙度RZ50

Weight app.:	1932,6 kg	Proprietary class: Restricted	EC 3
Part:	Main beam, RESS		Sheet no.: 2/5
Draw. format:	A2	Draw. scale:	1:20
ISO		Revision:	001
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Siemens Wind Power A/S		D1359929	
上海电气 上海电气风电集团有限公司		Shanghai Electric Wind Power Group Co., Ltd.	

Welding Assembly

Note Q-1:Welding symbols according to ISO 2553:1992



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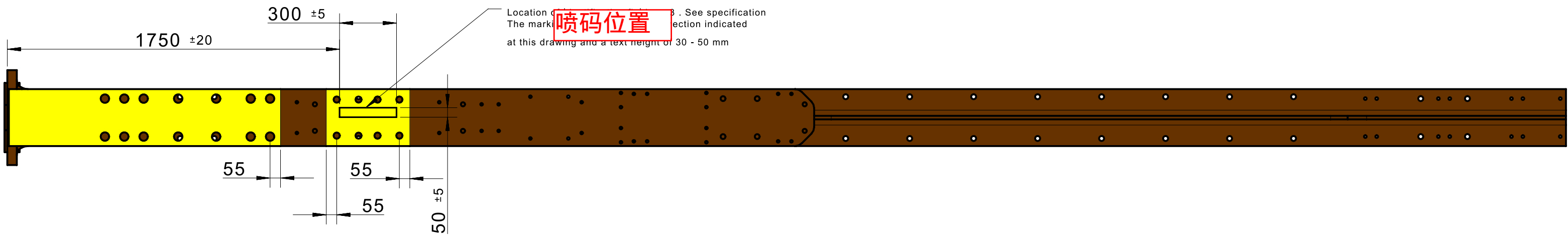
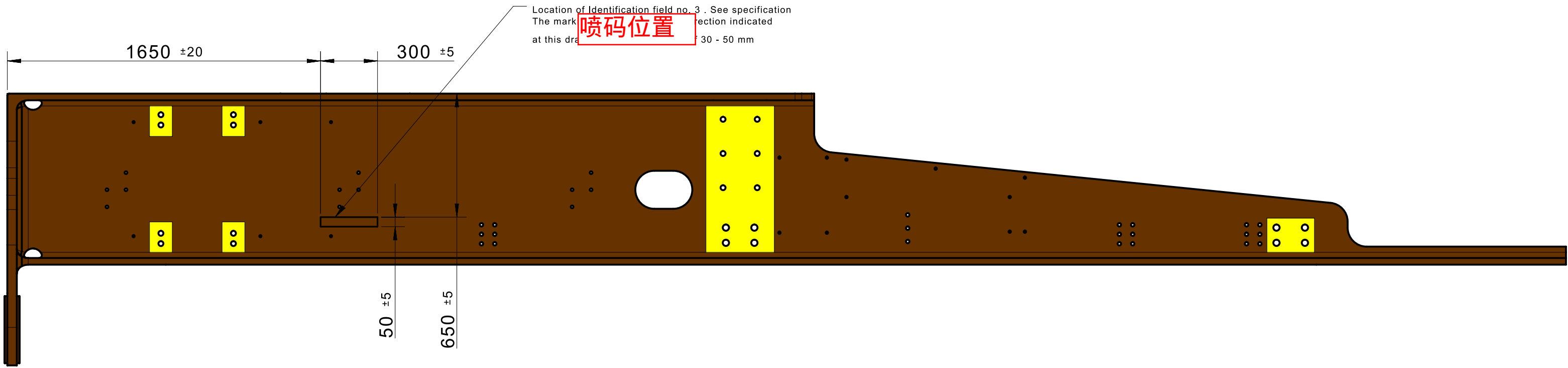
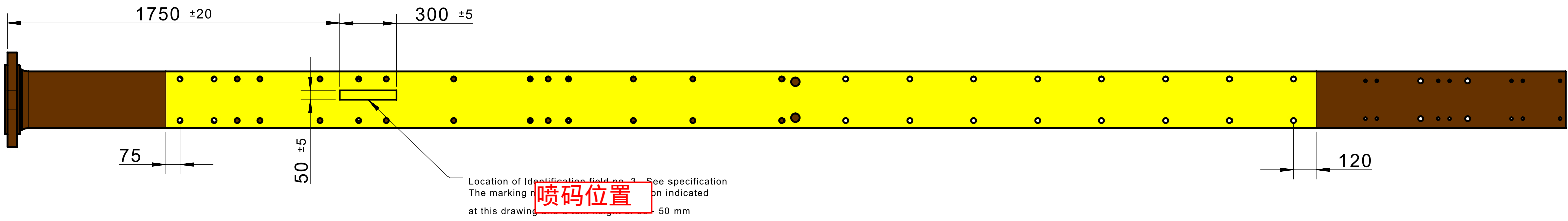
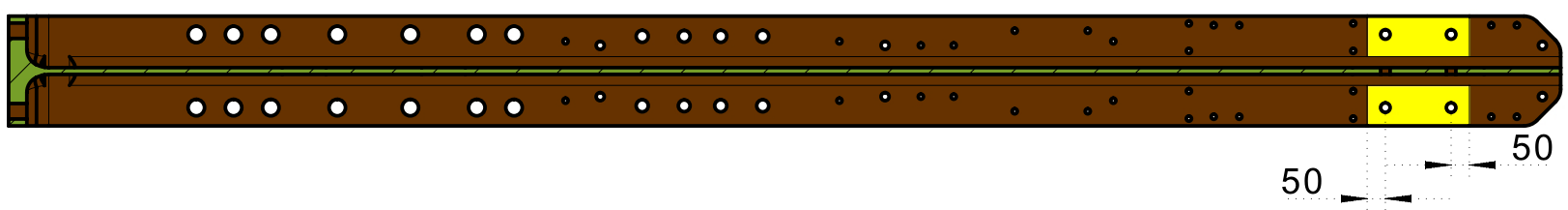
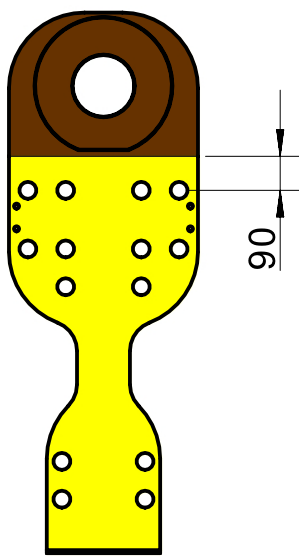
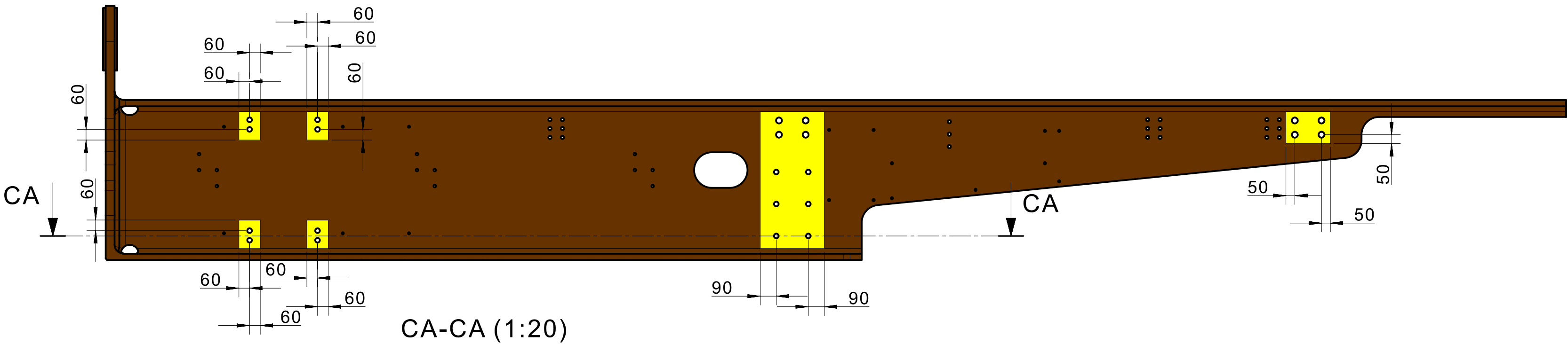
Note 1: Area to be machined after welding
Note 2: Before welding of the profile (POS 1) IBP 900-DIN 1025-2 to the machined end plate (POS 2) it must be ensured that the end of the profile (POS 1) to be welded, has been tested for internal soundness, according to the specification.

Weight app.: 1932,6 kg	Proprietary class: Restricted	EC 3	
Part: Main beam, RESS	Draw. format: A1	Draw. scale: 1:20	Sheet no.: 4/5
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Surface corrosion protection system

Location of reference areas.

Color:	Used for:
<div></div>	M-1-1
<div></div>	M-1-2



通用要求：
1.清洁度Sa3
2.粗糙度85-130um
3.所有自由边倒角R2
M-1-1：法兰接触面。热喷锌，膜厚60-160um
M-1-2：C4要求。热喷锌，膜厚90um

喷码要求(上海电气)：

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SWP: 西门子风电

CN: 中国 (零件运往何处)

07214: 飞跃代码

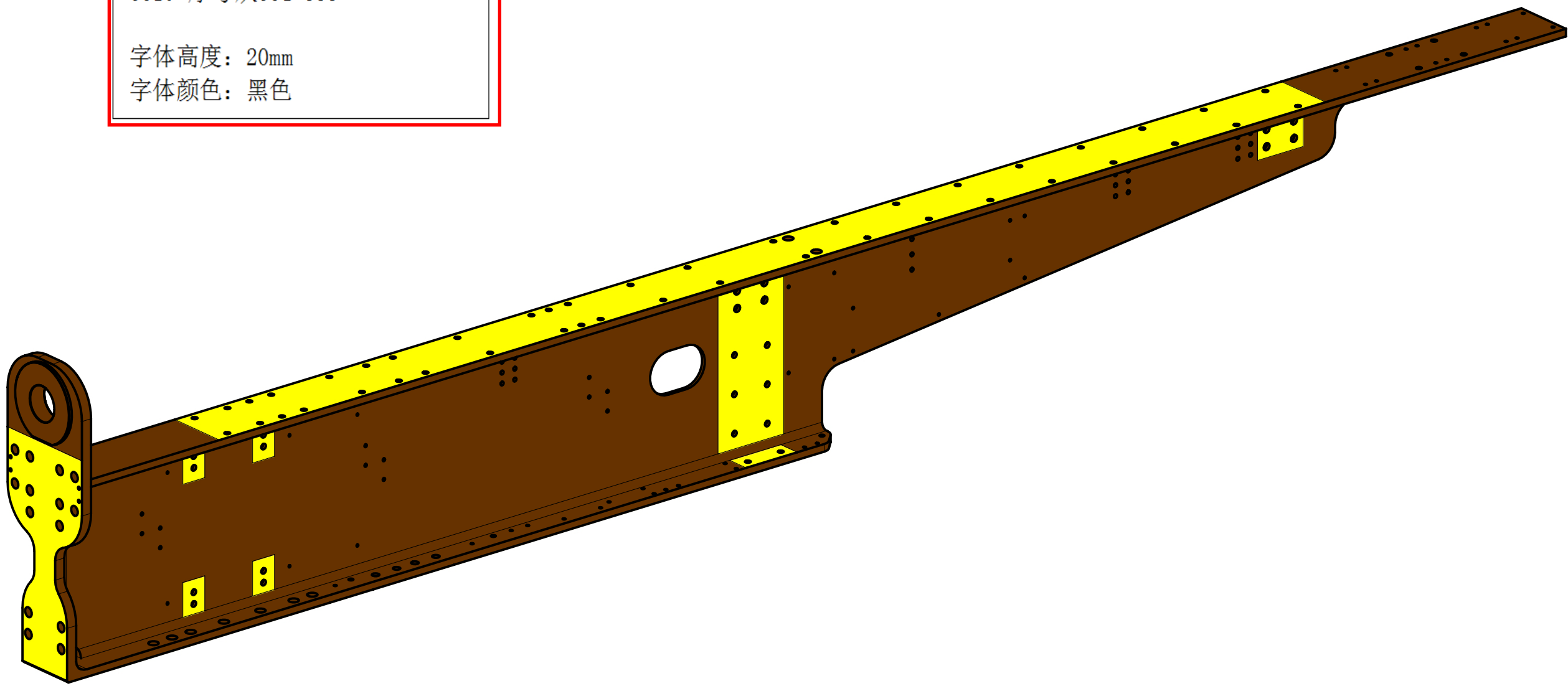
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01: 生产月份 (根据实际生产年份)

001: 序号从001-999



字体高度: 20mm

字体颜色: 黑色



Alle uangivne tolerancer: ±5 mm
Unspecified tolerances: ±5 mm

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Weight app.: 1932,6 kg		Proprietary class: Restricted		EC 3	
Part: Main beam, RESS		Draw. format: A1	ISO 	Draw. scale: 1:20	Sheet no.: 5/5
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Siemens Wind Power A/S		上海电气风电集团有限公司 Shanghai Electric Wind Power Group Co., Ltd.		D1359929	